

# Work Order ID 76498

**\*76498\***

Page 1

Tuesday, November 15, 2011 4:00:17 PM

Item ID: D3325-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid Assembly  
 Start Date: 11/15/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 11/25/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: *[Signature]* Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3325	Rev B								

100  
**\*100\***  
 Large Fab  
 Large Fab  
 Large Fab  
 Memo  
 1-Cut tubes as per Dwg D3325  
 QtyPart Number Description Batch  
 2D3325-1EndTube 119683  
 3D3325-3Interior Tube 119683  
 2D3325-5Full Lengh Tube 119683  
 Identify parts appropriately  
 2-Remove all markings from material  
 3-Drill and Weld as per Dwg D3325 & QSI 004  
 A/R4130Steel Rod 118875  
 4-Deburr as required

*CP 11-11-25*

*(IX) [Signature]*

**\*76498\***

Tuesday, November 15, 2011 4:00:17 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

Stop \*NS2\*

**Item Name:** Basket Lid Assembly

**Start Date:** 11/15/2011    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 11/25/2011      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

121

Pressure Wash per QSI005 4.3

0.00

**\*121\***

HandFinish

## Memo

0.00

## Hand Finishing

# Work Order ID 76498

**\*76498\***

Page 3

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 Required Date: 11/25/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*130*</b>									
Powdercoat		0.00							
Powder Coating									
	<div>Memo</div> <div>1ST COAT: 3:10</div> <div>START TIME: 4:00</div> <div>OVEN TEMPERATURE: 400°F</div> <div>FINISH TIME: 3:40</div> <div>***** 2nd coat if necessary*****</div> <div>2ND COAT: 3:50</div> <div>START TIME: 4:00</div> <div>OVEN TEMPERATURE: 400°F</div> <div>FINISH TIME: 4:20</div>								
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC		0.00							
Quality Control									

*Handwritten: X m-f 11/11/08*

*Handwritten: 1 PR 11-11-08*

*Handwritten: W 118439*

# Work Order ID 76498

**\*76498\***

Page 4

Tuesday, November 15, 2011 4:00:17 PM

Item ID: D3325-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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 Item Name: Basket Lid Assembly  
 Start Date: 11/15/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 11/25/2011 Req'd Qty: 1.00 **\*1\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>G-A</i>	0.00							
<b>*150*</b>									
Packaging	Memo <i>w/o</i>	0.00							
Packaging	<i>76490 (A)</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*ES 11/11/29* *(Signature)*

*11/11/29* *(Signature)*  
*MF*  
*11-11-29*

# Picklist Print

Tuesday, November 15, 2011 4:00:21 PM

Page 1

Work Order ID: 76498

\*76498\*

Parent Item: D3325-041

\*D3325-041\*

Parent Item Name: Basket Lid Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3328-1 Basket Hinge		Manufactured	No			100	Each	17.0000	2	2	**	PCL 11.11.21	
*D3328-1*													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				17					
				33871				17					
✓ D3349-1 Spacer Bushing		Manufactured	No			100	Each	22.0000	2	2	**	PCL 11.11.21	
*D3349-1*													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				22					
				44401				22					
✓ D3352-1 Label Plate		Manufactured	No			100	Each	11.0000	1	1	**	PCL 11.11.21	
*D3352-1*													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				11					
				41925				11					
✓ D3367-1 Mounting Bracket		Manufactured	No			100	Each	8.0000	2	2	**	PCL 11.11.21	
*D3367-1*													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				8					
				43228				8					

\$76500 → (2)

# Picklist Print

Page 2

Tuesday, November 15, 2011 4:00:21 PM

Work Order ID: 76498

**\*76498\***

Parent Item: D3325-041

**\*D3325-041\***

Parent Item Name: Basket Lid Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

307.3682

20.5416

21.62274

**\*M4130NTS0 500W 035\***

4130 Square tube .500 x .500 x .035w

\*\*

*PL 11.11.21*

Location

Loc Qty

Loc Code

MAT034

307.3682

109127

158.152

109385

15.75

112786

39.2488

119441

57.8774

119506

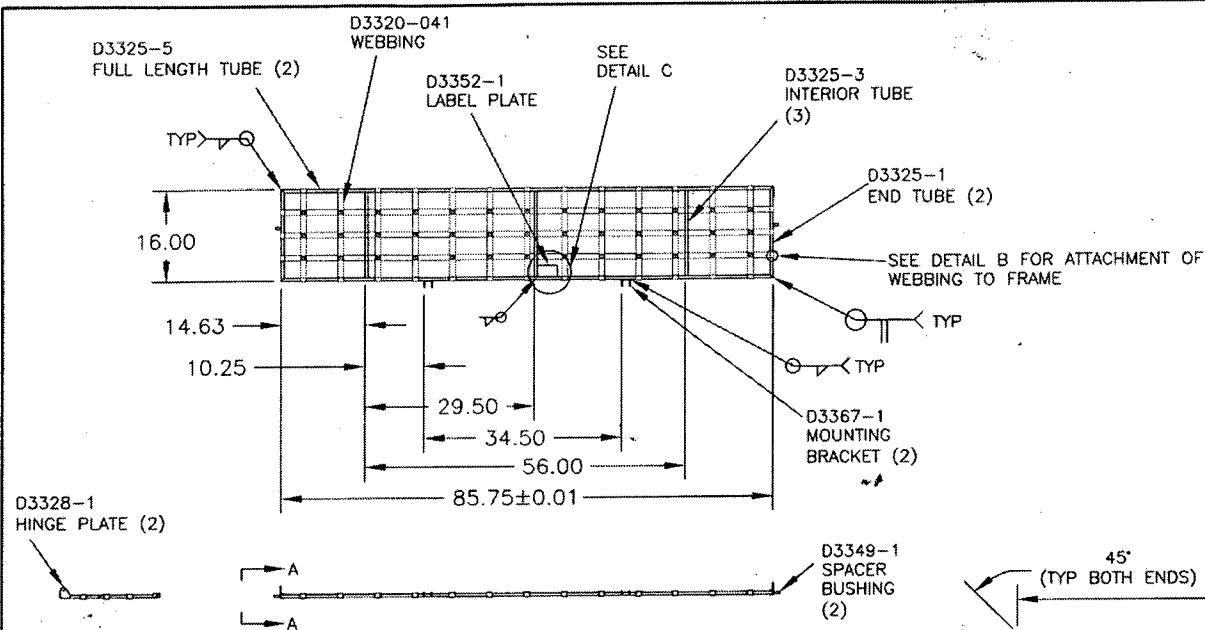
36.34

*m119683 → 21.6227*

Tuesday, November 15, 2011 4:00:22 PM

Shop Packet Print

Page 2



#### D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

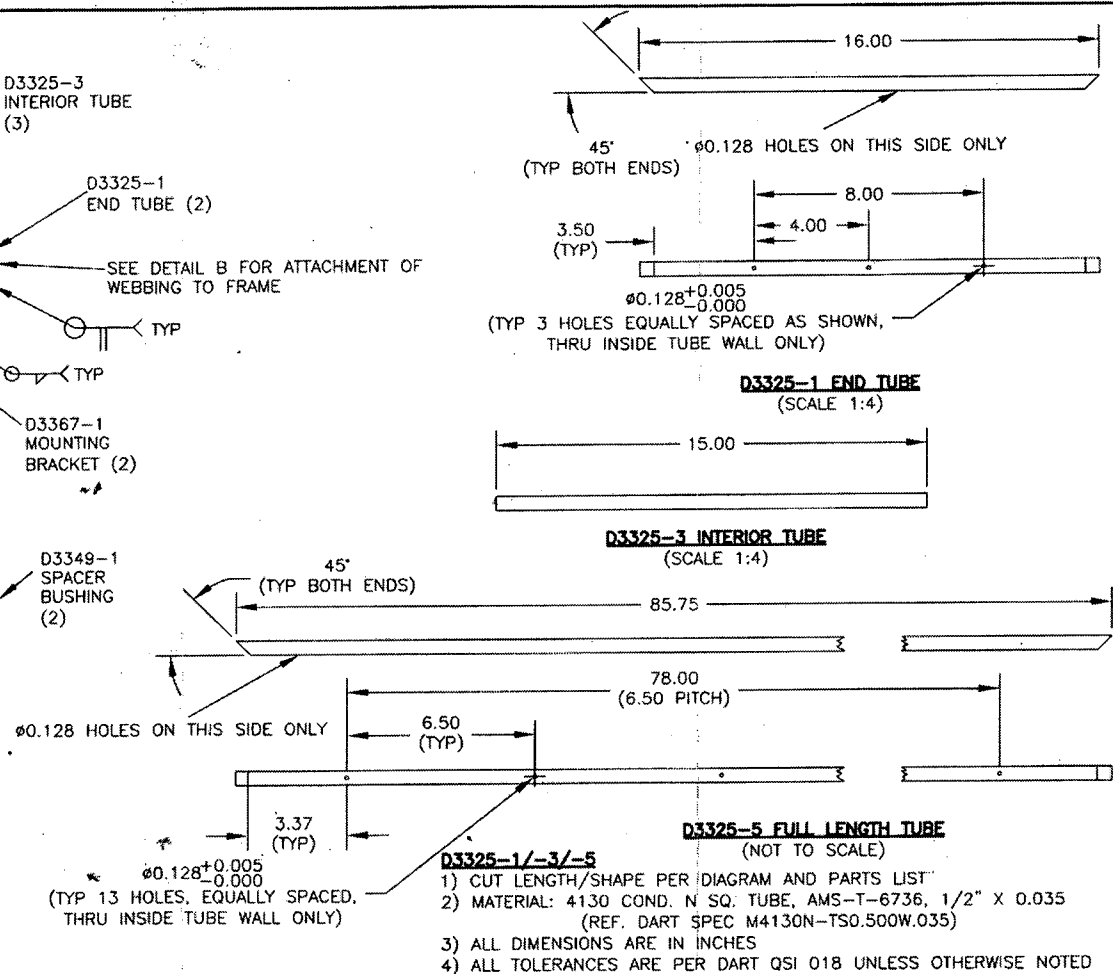
Part No.	Quantity	Description
D2728-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN880J9	32	WASHER

RELEASED  
05-04-28

DEO ATTACHED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 76498



B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	CW	DRAWN BY
CHECKED	AW	APPROVED
DATE	05.04.25	TITLE
		BASKET LID ASSEMBLY
		SCALE
		1:20

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DART AEROSPACE LTD.

**DART** DART AEROSPACE LTD.  
BURLINGTON, ONTARIO, CANADA

DRAWING NO. D3325  
REV. B  
SHEET 1 OF 3

11-1175

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

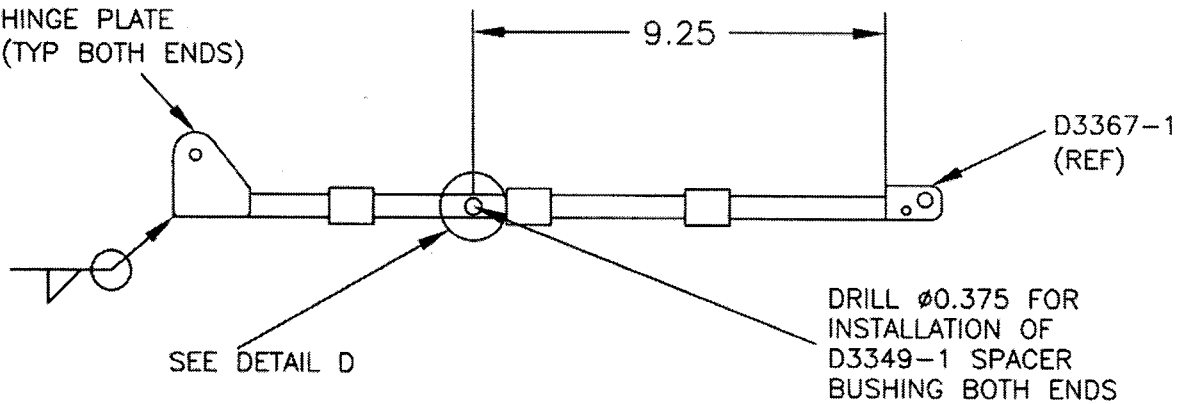
**NOTE:** Date & initial all entries





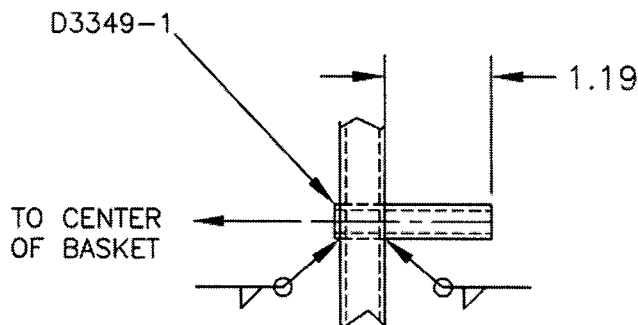
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1  
HINGE PLATE  
(TYP BOTH ENDS)



VIEW A-A

76495  
86472



DETAIL D  
(SCALE 1:2)

DEO ATTACHED  
RELEASED  
05.04.28 [Signature]

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

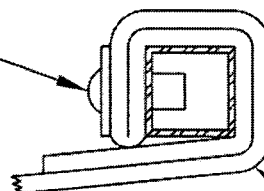
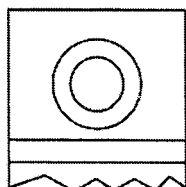
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



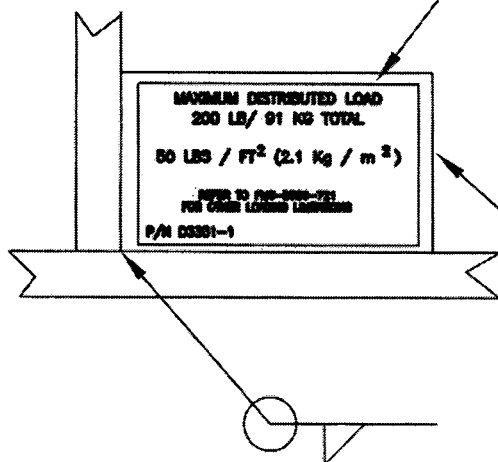
DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

D3320-041 WEBBING

*g b h l*

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1

RELEASED  
05.04.28 *[Signature]*  
DEO ATTACHED



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

**PART LIST FOR D3325-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description

**IS:**

MS20600AD4W5	32	RIVET

**WAS:**

MS20600AD4W3	32	RIVET

*76448*

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries